

AMENDMENTS TO THE CLAIMS:

Please replace the claims with the claims provided in the listing below wherein status, amendments, additions and cancellations are indicated.

1. (Currently Amended) A method of manufacturing an outer ring member of a bearing device for ~~vehicle whose outer ring comprises: a vehicle, the outer ring member having an axial first end toward a vehicle inner side, the outer ring member comprising:~~

a cylindrical main body portion [[comprising]] having a raceway [[in]]
along an inner peripheral surface thereof;

a flange provided in portion extending radially outward from an outer peripheral surface of the main body portion and toward said axial first end; on a vehicle inner side of the cylindrical main body; and

a cylindrical fitting tolerance portion part provided further on the vehicle inner side located axially further toward the axial first end than the flange portion,
wherein-

~~the cylindrical main body is made turning in a state where the flange is held by a holding device.~~

the method comprising:

turning the cylindrical main body portion while holding a radially-outward peripheral surface of the flange portion with a holding device.

2. (Currently Amended) ~~The method of manufacturing the bearing device for vehicle according to Claim 1, wherein A method of manufacturing a bearing device for a vehicle, the bearing device having an outer ring with an axial first end toward a vehicle inner side, the outer ring comprising:~~

a cylindrical main body having a raceway along an inner peripheral surface thereof;

a flange at an outer peripheral surface of the outer ring and toward said axial first end;

a cylindrical fitting tolerance located axially further toward the axial first end than the flange,

the method comprising:

turning the cylindrical main body is made turning and then heat-treated; and while holding the flange with a holding device;

heat-treating the cylindrical main body;

after the heat-treating, turning to be finished a side surface of the flange on the vehicle-inner-side of the flange and an outer peripheral surface of the

cylindrical fitting tolerance part are made turning to be finished after the heat treatment.

3. (Currently Amended) The ~~method of manufacturing the bearing device for vehicle according to Claim 2, wherein~~ manufacturing method of claim 2, wherein the side surface on vehicle-inner-side and the outer peripheral surface of the cylindrical fitting tolerance part are made turning to be finished referring to the outer peripheral surface of the cylindrical main body after turning as a standard grinding level after the outer peripheral surface of the cylindrical main body is held in the turning step to be finished.

4. (Currently Amended) The ~~method of manufacturing the bearing device for vehicle according to Claim 1, manufacturing method of claim 1, wherein~~ said flange holding comprises holding the flange portion ~~is held~~ at a plurality of positions [[in]] at an outer peripheral surface of the [[flange]] flange, the plurality of positions being spaced to one another at circumferentially equal intervals [[when]] while the flange portion is held.

5. (Currently Amended) The ~~method of manufacturing the bearing device for vehicle according to Claim 4, manufacturing method of claim 4,~~

wherein the flange portion comprises in a circumferential direction a plurality of alternating large-diameter flanges provided with bolt holes and small-diameter flange portions, each large-diameter flange portion having a bolt hole, flanges provided between the large-diameter flanges in the circumferential direction,

wherein said flange holding comprises holding the flange portion with a plurality of holding parts is used when the flange is held, and parts, each one of the plurality of holding parts a holding part comprising a recessed part recessed toward an outer-diameter side and having a dimension capable of housing one of the large-diameter flange portions on an inner-periphery side, is used as at least one of the plurality of holding parts. side.

6. (New) The manufacturing method of claim 1 in which the bearing device comprises the outer ring member; an inner ring member having a portion concentrically inward of the outer ring member; a hub shaft having a portion concentrically inward of the inner ring member; a plurality of roller bodies between the inner ring member and outer ring member; and a plurality of retainers.

7. (New) A method of manufacturing a bearing device for a vehicle, the bearing device having an outer ring with an axial first end toward a vehicle inner side, the outer ring comprising:

a cylindrical main body having a raceway along an inner peripheral surface thereof;

a flange at an outer peripheral surface of the outer ring and toward said axial first end;

a cylindrical fitting tolerance located axially further toward the axial first end than the flange,

the method comprising:

turning the cylindrical main body while holding the flange with a holding device;

heat-treating the cylindrical main body to harden said raceway;

after the heat-treating, forming a hole in the flange;

after the hole forming, turning a side surface of the flange on the vehicle-inner-side and an outer peripheral surface of the cylindrical fitting tolerance part to remove thermal strain and distortion which may have resulted from said hole forming.

8. (New) The manufacturing method of claim 7, in which said flange holding comprises holding the flange at a plurality of positions at an outer peripheral surface of the flange, said plurality of positions being spaced to one another at circumferentially equal intervals while the flange is held.

9. (New) The manufacturing method of claim 7,
in which the flange comprises in a circumferential direction a plurality of alternating large-diameter and small-diameter flange portions,
wherein said hole forming comprising forming a hole at each one of the large-diameter flange portions,
wherein said flange holding comprises holding each one of the plurality of large-diameter flange portions with said holding device, the holding device including a plurality of holding parts, each one holding part comprising a recessed part recessed toward an outer-diameter side and having a dimension capable of housing one of the large-diameter flange portions on an inner-periphery side, and
wherein said flange holding further comprises adjusting position of at least one of the plurality of holding parts.